

Asal !! Split - 1

Work Order ID 121501

121501

Page 1

Item ID: D4866-2

Revision ID:

Item Name: Strut

Start Date: 6/26/14

Start Qty: 24.00

Required Date: 6/26/14

Req'd Qty: 24.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: 14-06-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4866	B								

100

0.00

100

Doosan

Doosan Lathe

DOOSAN LATHE

Memo

1- Turn as per Folio FB259

Rev: N/A & Dwg D4866 Rev: 13

0.00

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

DAS
13
8-8

DAS
13
8-8

14-9-5

14-9-5

Work Order ID 121501

121501

Page 2

Thursday, June 26, 2014 3:01:35 PM

Item ID: D4866-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut

Start Date: 6/26/14 Start Qty: 24.00

24

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 24.00

24

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
25
9-89

14-9-5

130 Outsource process - NDT per QSI038 4.1

0.00

130

Outsource2

Memo

0.00

Outsource process - NDT

ISSUE P/O : 25651

C OF C IS REQUIRED

CD 14/09/03 2

140 Receive & Inspect for Damage & Mat'l Certs

0.00

140

Packaging

Memo

0.00

Packaging

Per 6/26/14

Thursday, June 26, 2014 3:01:35 PM

Page 3

MLS 24-09-10
MF
14-9-9

Picklist Print

Page 1

Thursday, June 26, 2014 3:01:34 PM

Work Order ID: 121501

121501

Parent Item: D4866-2

D4866-2

Parent Item Name: Strut

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 24.00

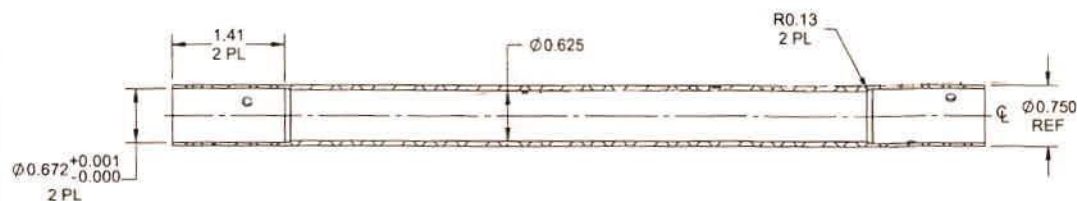
Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 14-01-14 JLM VERIFIED BY:DD

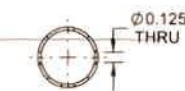
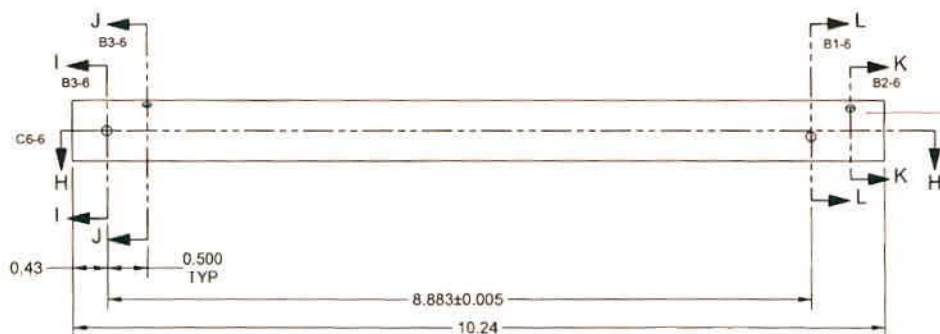
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.750		Purchased	No				f	15.1958		23.11579			
M174PH-H900R0 750									**	<u>14-9-5</u>			DAS 13 9-89
17-4 SS H900 ROUND BAR 0.750"													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT031	15.1958	
M127334	3.8	
M128809	11.3958	

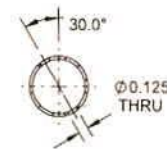
129892



SECTION H-H B8-6



SECTION I-I C8-6



SECTION J-J C7-6



SECTION K-K C4-6



SECTION L-L C5-6

D4866-2 STRUT

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

121501 MJS
1406-27

RELEASED
2014-06-16

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4866	SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.04.08	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

Page: 1 of 1

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20446	Customer: Cash Sale	Dept: NDT YUL	Reference: 25651
Descr:	PN: DART AEROSPACE	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task:			Sequence: 0

Work Required:

CARRY OUT NDT ON THE FOLLOWING ITEMS:

① ITEM ID D412-596-203 - 39" AFT CROSS TUBE - WORK ORDER ID 105505

② ITEM ID D4866-2 - STRUT - WORK ORDER ID 121501 QTY 2

Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE IAW ASTM E1417-M13		
① WORK ORDER ID 105505 = NO CRACKS FOUND	5 SEP 14	
② WORK ORDER ID 121501 = NO CRACKS FOUND	5 SEP 14	

Description	Location	P/N	Qty	Batch	S/N Off	S/N On
BLACK LIGHT		S/N T-20990N				
PENETRANT		ARDROX 970P25E		BATCH#	02312131	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: 05 SEP 2014
Name: GARY SMITH		